

Date: Friday, 01/08/2008 10:46:19 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT FACING SEAT ASS'Y LH
Job Number :	40918		
Estimate Number :	13306		
P.O. Number :		Part Number :	D412769043
This Issue :	01/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D412-769-1 REVB
First Issue :	/ /	Project Number :	N/A
Previous Run :	40917	Drawing Revision :	B
		Material :	
Written By :		Due Date :	22/08/2008
Checked & Approved By :	JUL 08. 8.9	Qty:	1 Um: Each
Comment :	Est rev A 08.05-12 new issue DD verified by:EC Est Rev:B 08-07-17 revB as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3782045	Back Leg Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Back Leg Assembly
 batch: 40873

80

3.0	D3782041	Front Inboard Leg Assembly
-----	----------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Front Inboard Leg Assembly
 batch: 42135

FF 08/10/16

4.0	D3782043	Front Outboard Leg Assembly, LH
-----	----------	---------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Front Outboard Leg Assembly, LH
 batch: 42137

FF 08/10/16

5.0	D3783041	Lateral Brace Assembly
-----	----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Lateral Brace Assembly
 batch: 40874

8/10/9

SC

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:46:19 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40918

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D3783043	Longitudinal Brace Assembly
-----	----------	-----------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly

batch: 40875

sq

7.0	D3783045	Angle Brace Assembly
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly

batch: B 40876-5

sq 08/10/14

8.0	D3784041	Seat Support Assembly, Center
-----	----------	-------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center

batch: 40877

sq

9.0	D3784043	Seat Support Assembly, LH
-----	----------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH

batch: 40878

sq

10.0	D3784044	Seat Support Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH

batch: 40879

sq

11.0	D37661	Front Rail, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail

batch: 40863

sq

12.0	D37663	Rear Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail

batch: 40865

5/10/19

(X)

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40918

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D37671	Upper Rail
------	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: 40966

SP

14.0	D37921	Seat Belt Eye Bolt
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: 41923

SP

15.0	AN415A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108866

SP

16.0	AN45 13A	EYE BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M109012

SP

17.0	AN510A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M108827

SP

18.0	AN513A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

SP

19.0	AN960JD10	Washer
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Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M104625

M109059

(or NAS1149D0363J) batch:

8/10/9

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40918

Part Number: D412769043

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108827

(or NAS1149D0463J) batch: _____

SP

21.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M109059

(or NAS1149D0568J) batch: _____

SP

22.0

AN52510R24

Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108879

SP

23.0

MS21042L3

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M101625

M108701

SP

24.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M108145

SP

25.0

MS21042L5

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108161

81019

SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40918

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-1

FF 08/10/15 (1)

27.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

So 08/10/15 (2)

28.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:20
320 OF
2:50

M 08/10/15

29.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/10/15 (1)

30.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0	D37751	Guard
------	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guard

batch:

40869 6

FF 08/10/16 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40918

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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32.0	D37741	Seat Bottom, LH/RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Bottom, LH
batch: 41084

810

33.0	D37743	Seat Back, LH/RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Bottom, LH
batch: 40868

50

34.0	AN525 10R22	Screw
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Screw
batch: M109267

50

35.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Washer
batch: M105793
(or NAS1149D0332J) batch: _____

50

36.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)
Nut
batch: M108701

50

37.0	AN35A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
batch: 15205 ⁽³⁾ M100188

(1x)

38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1- install remaining parts as per dwg D412-769-1

8/10/9

50

PRO

FF 08/10/16

(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-769-043 PAR #: Fault Category: Prod/Ins. ass' med & small NCR: Yes No DQA: D Date: 08/10/23
 QA: N/C Closed: H Date: 08/10/23

NCR: <u>40918</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
03.10.16	33	During assembly employee Did not place the seat pan D3724-1 (Bottom) P.C. Human error/ Tech not paying enough attention	PH asi 042 03.10.16	Slot the four (4) side holes to 0.380" to allow Bolt to go through.	EF 08/10/16	PH asi 042 03.10.16		

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40918

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5086/16 @

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPD 40885

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/22

Job Completion



mk 08-10-22

Dart Aerospace Ltd

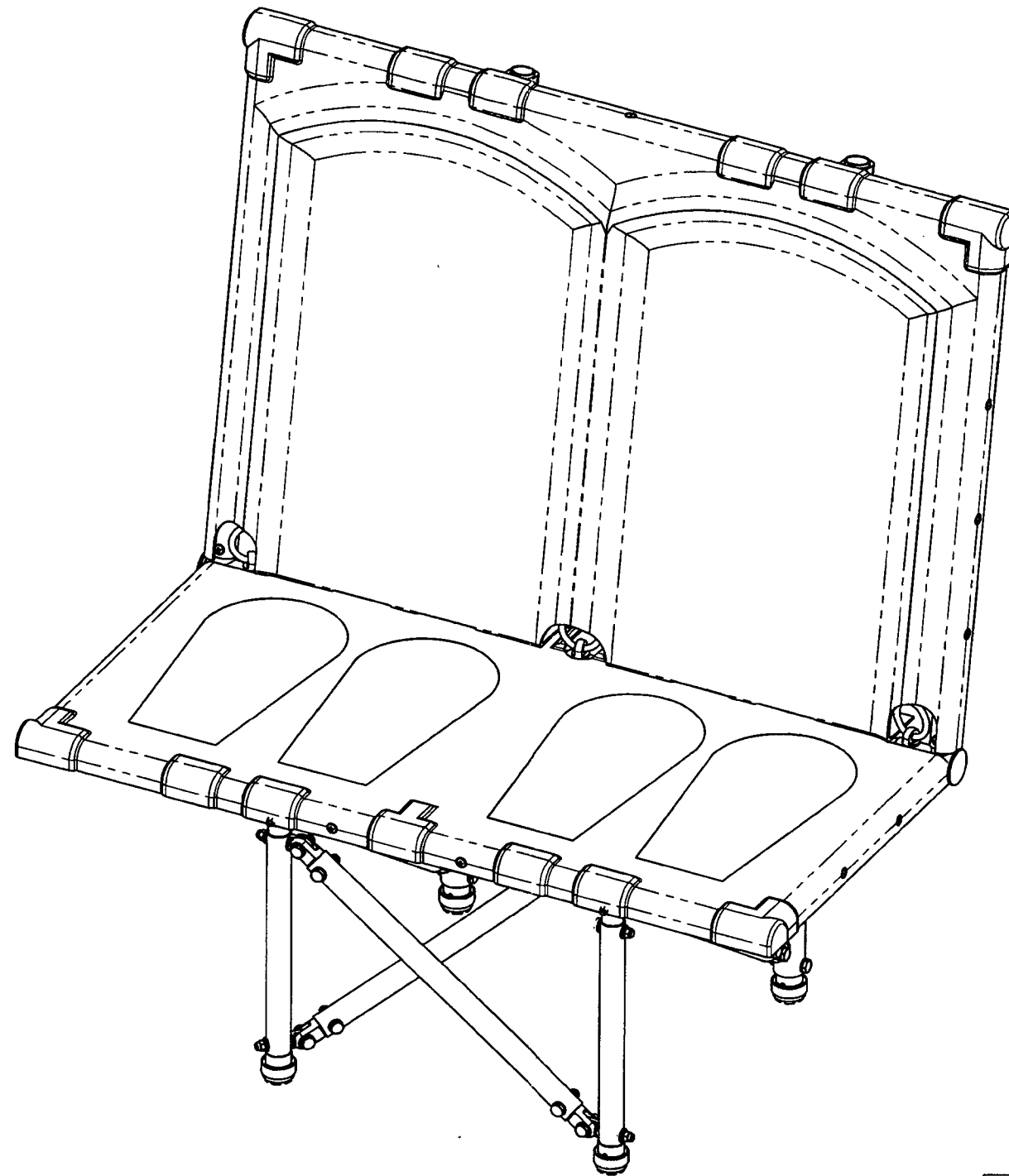
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



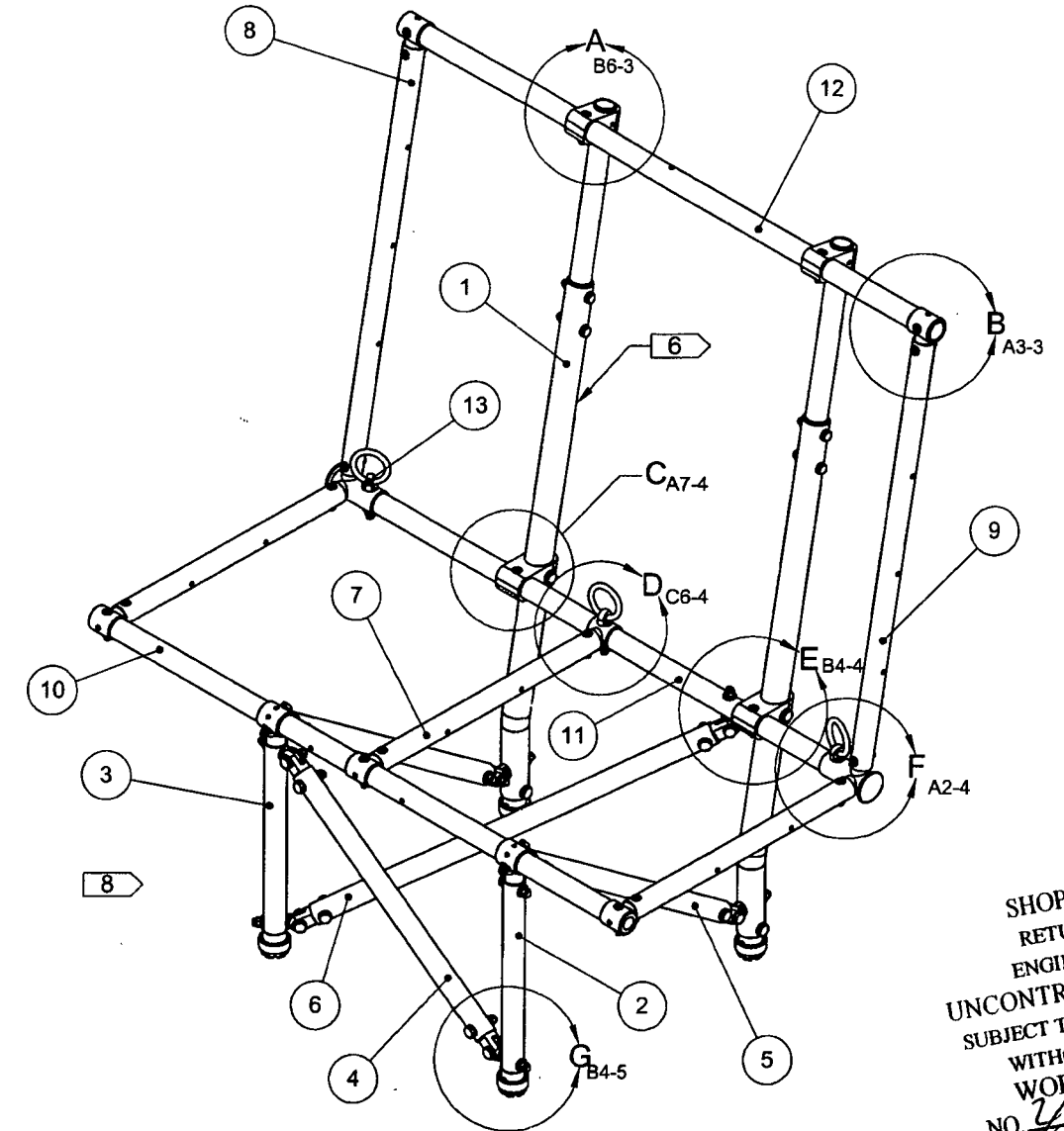
D412-769-043 AFT FACING SEAT ASSY, LH

REV.	DESCRIPTION	BY	DATE
B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-1	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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580709

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WITHOUT NOTICE
WORK ORDER
NO. *4098*

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



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NO. 4098

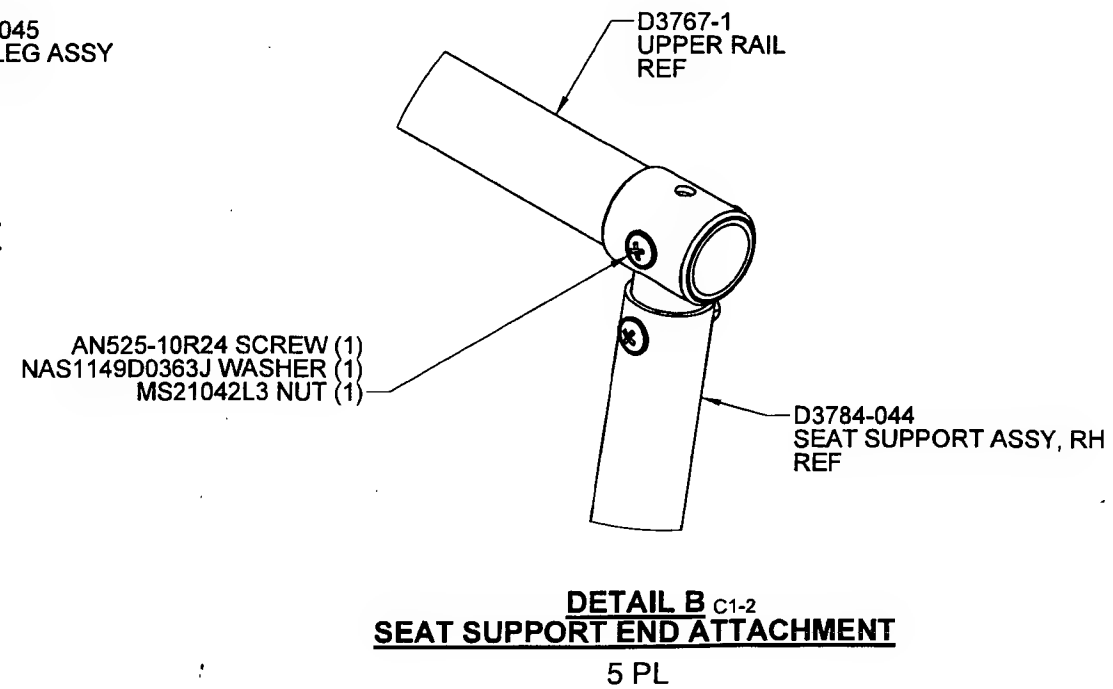
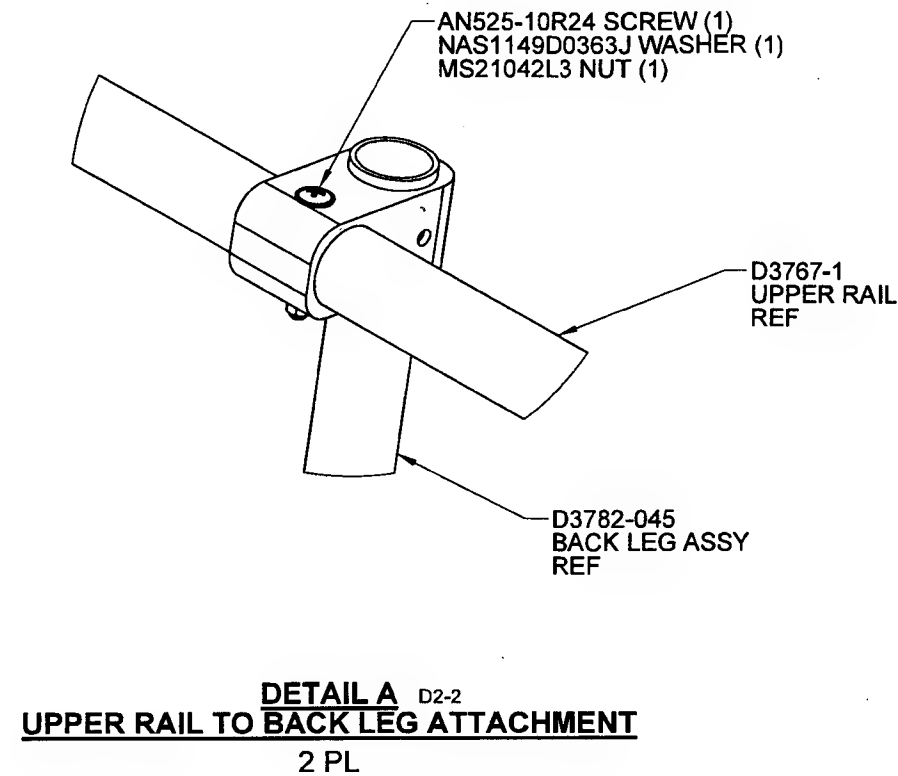
D412-769-043 AFT FACING SEAT ASSY, LH

RELEASED
08.07.09/11/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

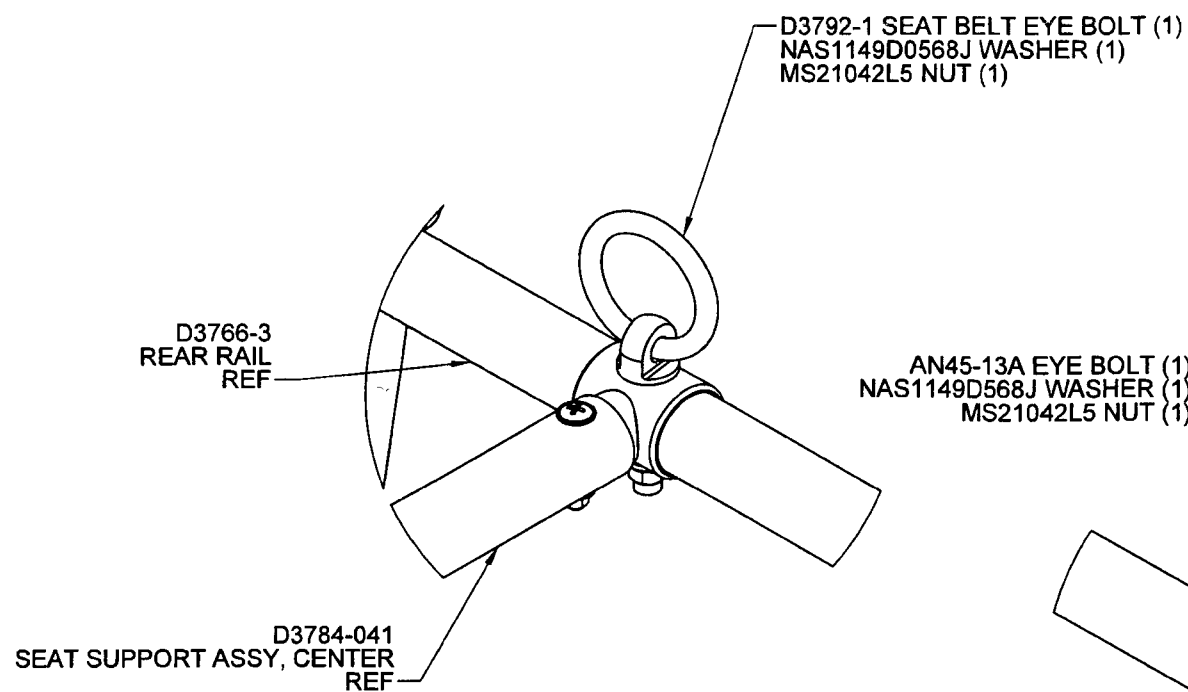


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NO. 40918

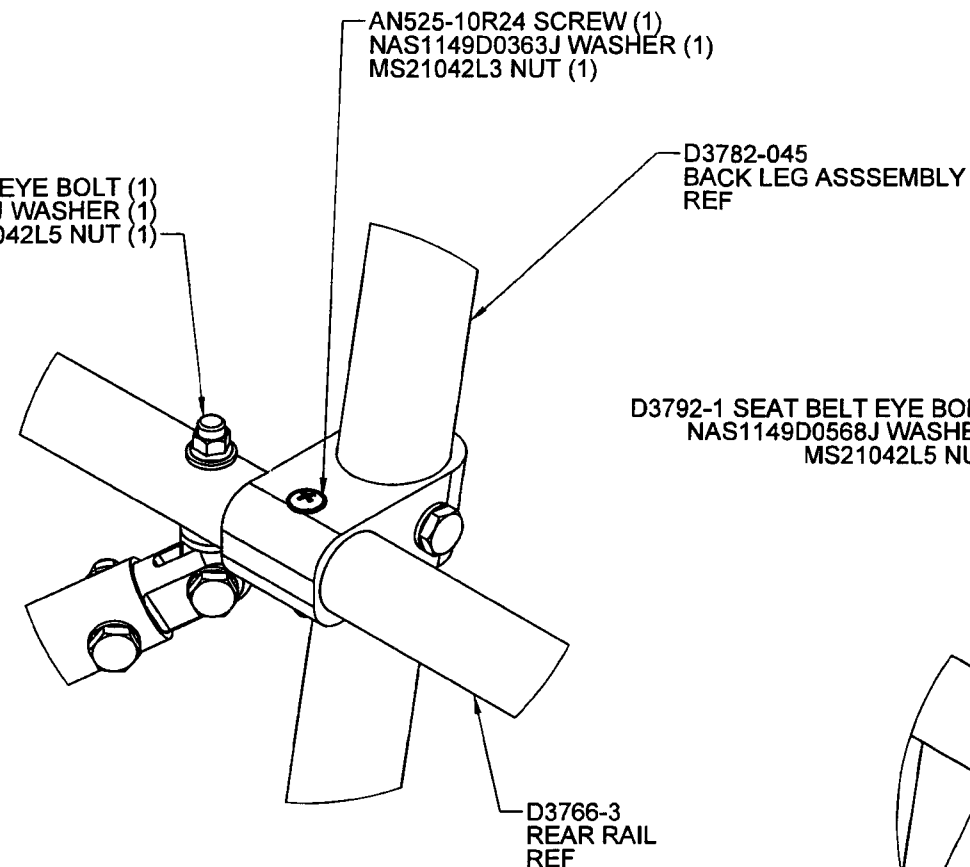
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08.07.11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-1	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, LH	NTS
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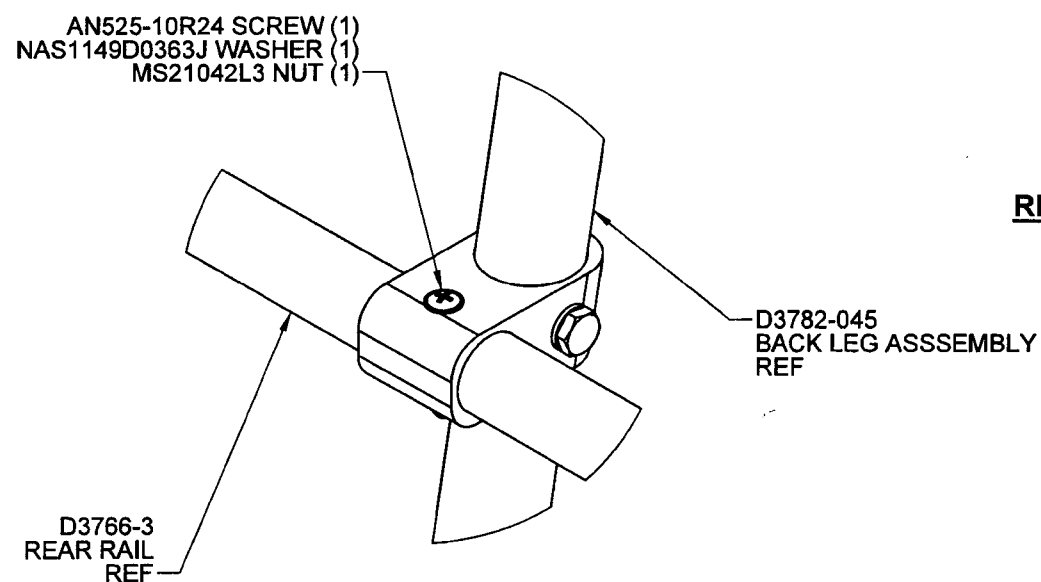
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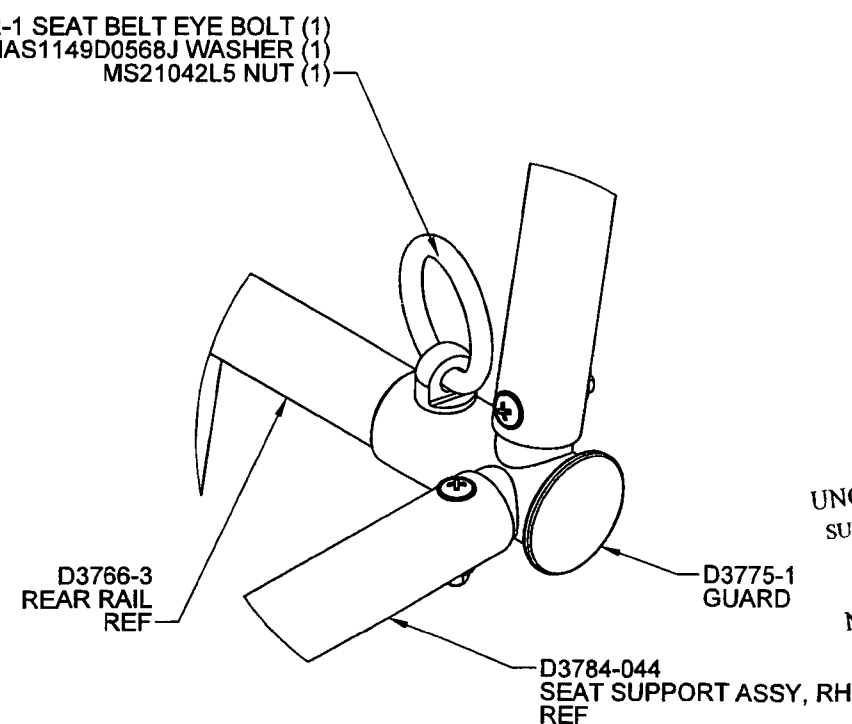
DETAIL D C2-2
SEAT SUPPORT ASSY, CENTER ATTACHMENT



DETAIL E C1-2
REAR RAIL TO BACK LEG ATTACHMENT



DETAIL C C2-2
REAR RAIL TO BACK LEG ATTACHMENT

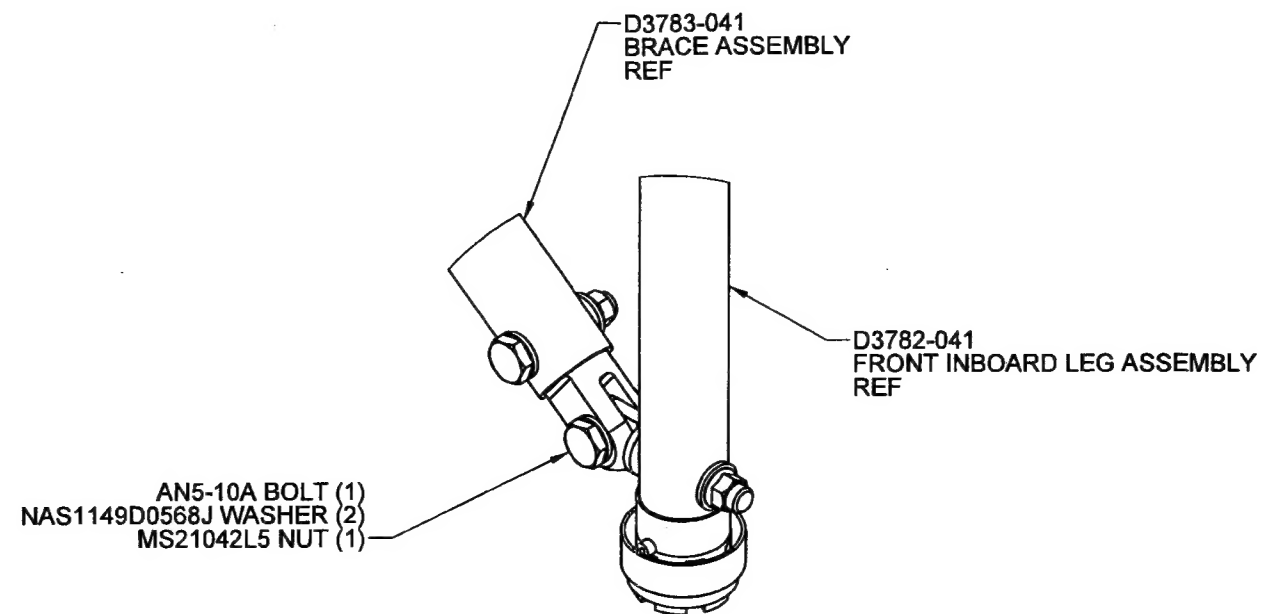


DETAIL F B1-2
SEAT SUPPORT ATTACHMENT
2 PL

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WORK ORDER
NO. 10078

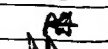
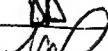

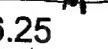
RELEASED
08.01.00.1110

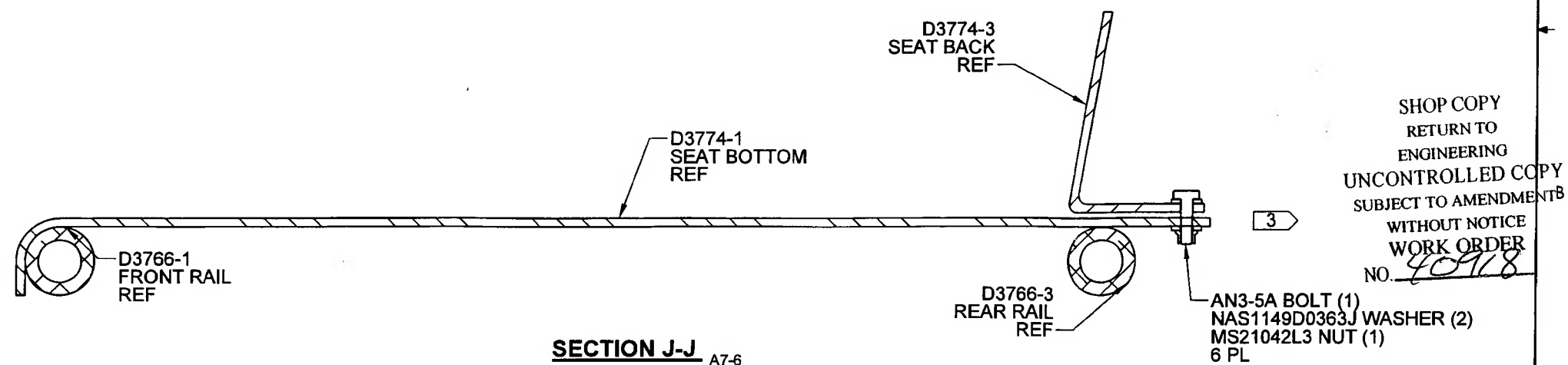
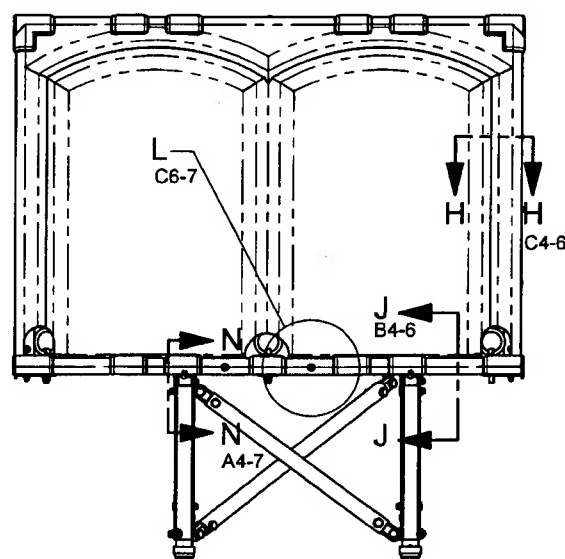
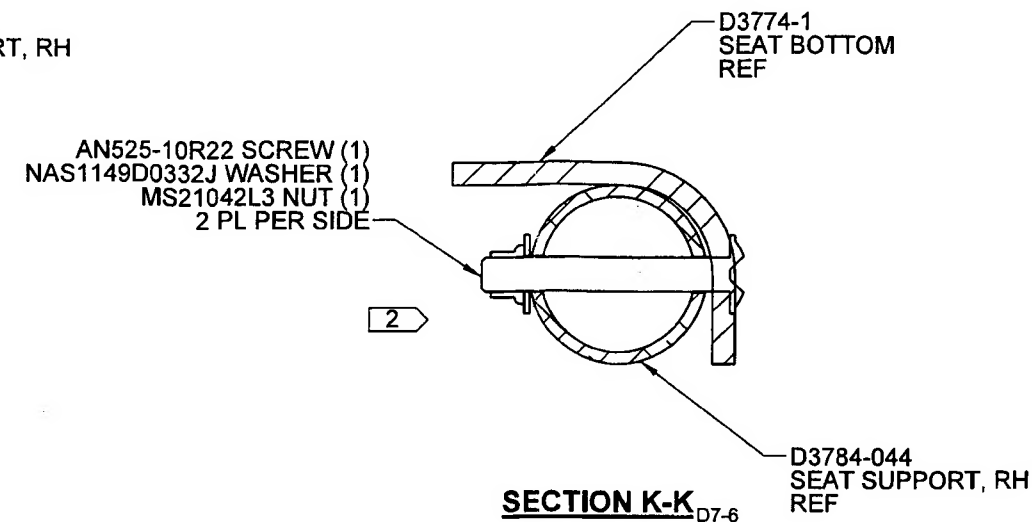
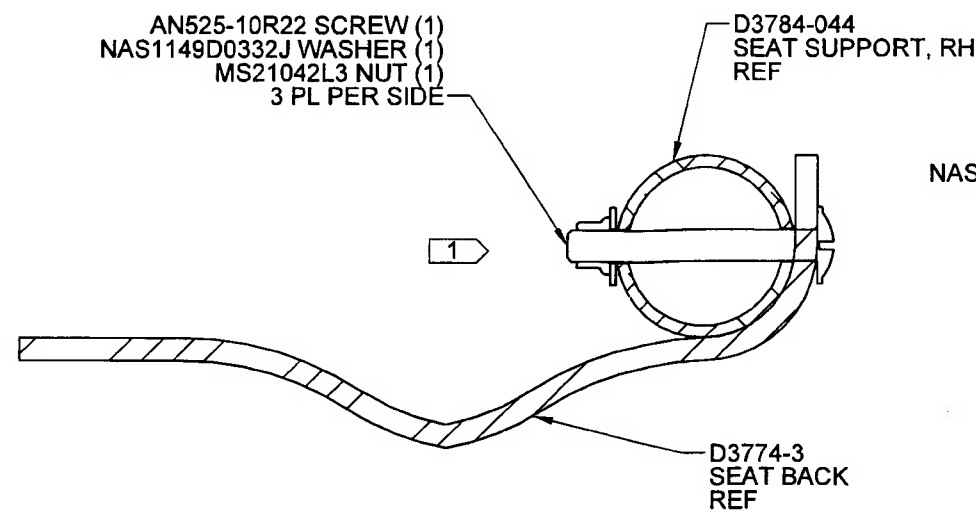
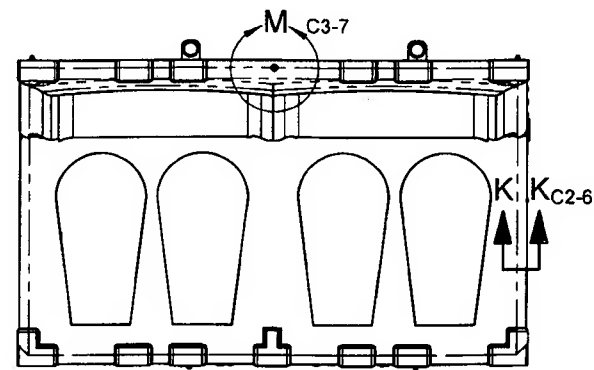
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, LH	NTS
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- NOTES:
1) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
2) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
3) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

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8

7

6

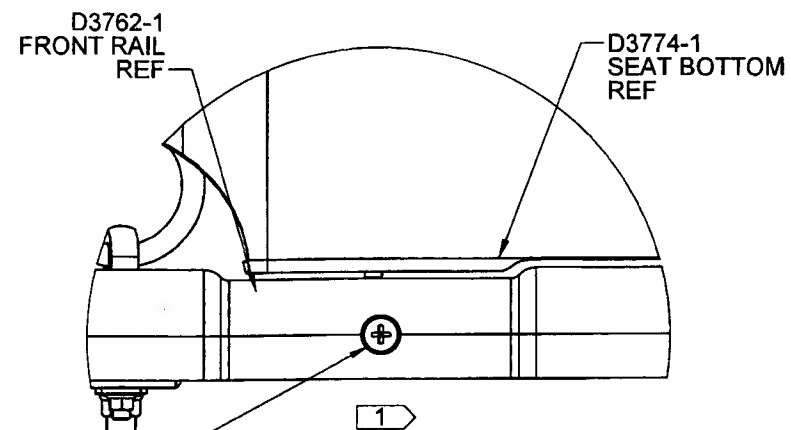
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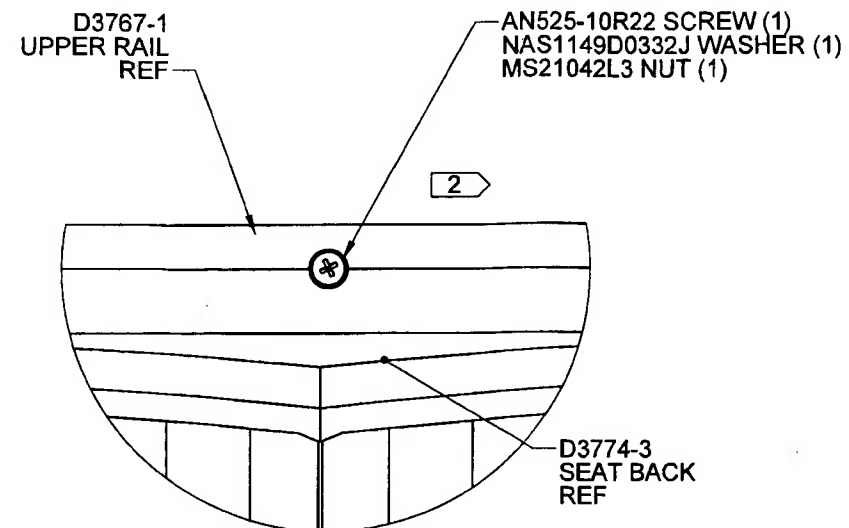
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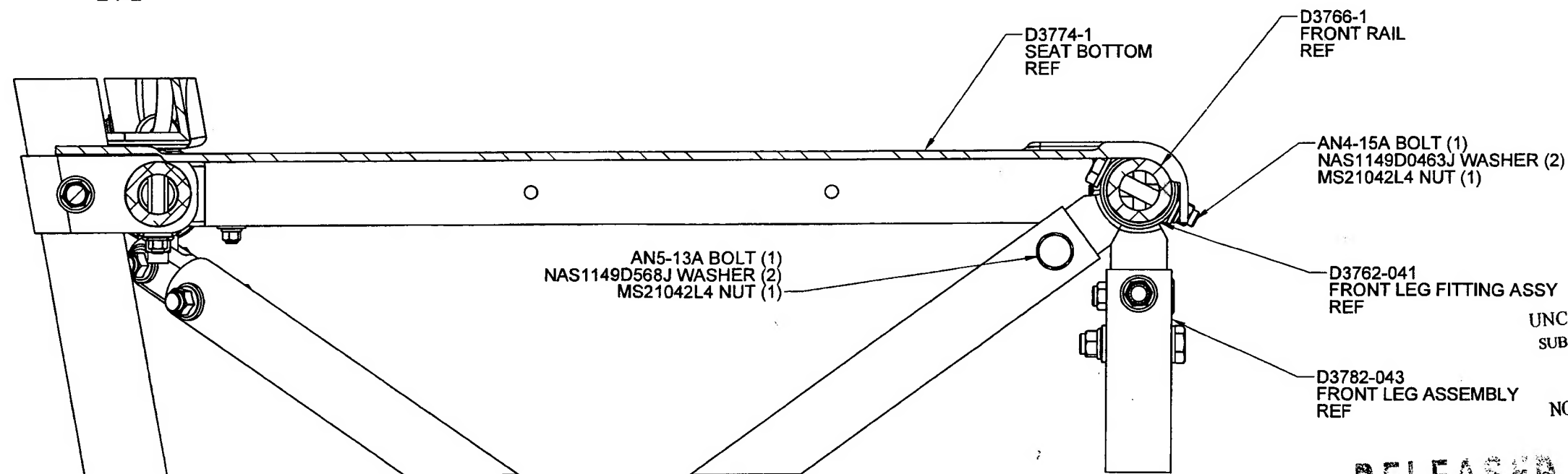


AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)

DETAIL L_{A7-6}
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL



DETAIL M_{D7-6}
SEAT BACK ATTACH - TOP DETAIL



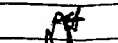
SECTION N-N_{A8-6}
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT
2 PL

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NOTES:

- 1) TRANSFER DRILL $\varnothing 0.201$ FROM FRONT RAIL (D3766-1) TO SEAT BOTTOM (D3774-1) - 2 PL
- 2) TRANSFER DRILL $\varnothing 0.201$ FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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